

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 159256

159256

Page 2

Thursday, April 06, 2017 2:54:02 PM

Item ID: D5346-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 4/7/2017 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 4/11/2017 Req'd Qty: 10.00 *10* Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 14 9-89
120						10	0		17/04/12
QC	Memo	0.20							
Quality Control									
130	Identify as per dwg & Stock Location: SH65	0.00							
130						10		APR 13 2017	DAS 8
Packaging	Memo	0.10							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									17/4/19
QC	Memo	1.00							
Quality Control									

W 17.04-18

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		OTHER : _____							

Picklist Print

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Page 1

Work Order ID: 159256

159256

Parent Item: D5346-3

D5346-3

Parent Item Name: Bushing

Start Date: 4/7/2017

Required Date: 4/11/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 16-01-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased	No			100	f	10.5230	0.0625	0.657895			DAS
M303R0 625									**			17-04-11	32 9-89

303 Round Bar 0.625"

Location

Loc Qty

Loc Code

MAT

2.077

m135463

2.077

MAT028

8.446

m136790

8.446

2.665'

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OTHER : ☐					

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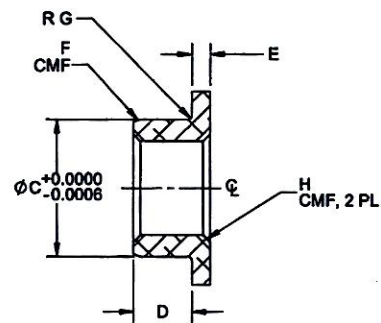
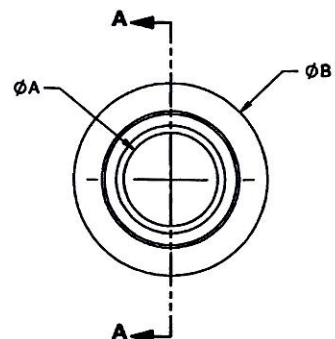


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		OTHER : _____							



SECTION A-A

D5346-X BUSHING

PART NUMBER	A	B	C	D	E	F	G	H	WEIGHT lbs
D5346-1	0.257	0.53	0.376	0.180	0.050	0.020 x 20°	0.010	0.020 x 45°	0.005
D5346-3	0.257	0.53	0.376	0.225	0.050	0.020 x 20°	0.010	0.020 x 45°	0.006
D5346-5	0.316	0.53	0.424	0.245	0.050	0.020 x 20°	0.010	0.020 x 45°	0.006
D5346-7	0.316	0.53	0.418	0.280	0.050	0.010 x 20°	0.010	0.020 x 45°	0.007

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
BY ORDER

159256 M5
1704-06

NOTES:

- 1) MATERIAL: AISI 303/304/316, STAINLESS STEEL ROUND BAR
PER ASTM A582 OR ASTM 276
(REF. DART SPEC M303R OR M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: SEE TABLE

PLEASED
2017-03-22
EN 17-535

APPROVED

B	ADDED -3/5-7 & TABLE (ZN B7-1)	RF	16.11.18
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	VS	D5346	SHEET 1 OF 1
MFG. APPR.	JFS	TITLE	SCALE
APPROVED	HS	BUSHING	NTS
DE APPR.	DS	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	16.11.18		

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